

7/19/19

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G03832-3G
Job Sheet 198017



Part No: RBW6205G03832-3G

Job Qty: 1 pcs

Part Name: Main Rotor Blade Blocking/Protecting Assembly



Part Weight: 0 lbs

Job Created: 7/19/19

Due Date: 9/20/19

Type: SOLD

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Priority: Medium

Description:

Note: DWG RBW6205G03832-3G Rev.5 IPP Rev. A 18.10.10 New issue DP Verify DD/IPP Rev. B 19.06.04
Removed Rev PO DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Workcenter / Supplier Lead Time	Sign-off
100	Purchasing	1 pcs		9/20/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
							Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S214274



Part: RBW6205G03832-3G

Job No: 198017

Serial No/Batch: S214274

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 08/17/19

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	1 pcs	9/20/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	SEP 18 2019
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	1 pcs	9/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	9/20/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 100 - (Purchasing) Issue P/O: _____ MANUFACTURE RBW6205G03832-3G AS PER DWG Supplier: METEC

Descriptions: Certificate of conformity is required

110 - (Receive & Inspect for Damage & Mat'l Certs)

120 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

DAS
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DAS
21
9-89

SEP 20 2019

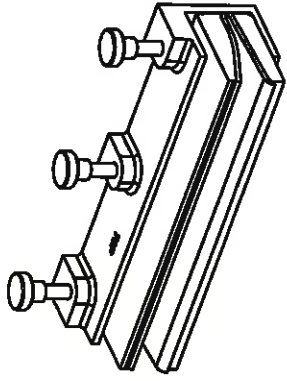
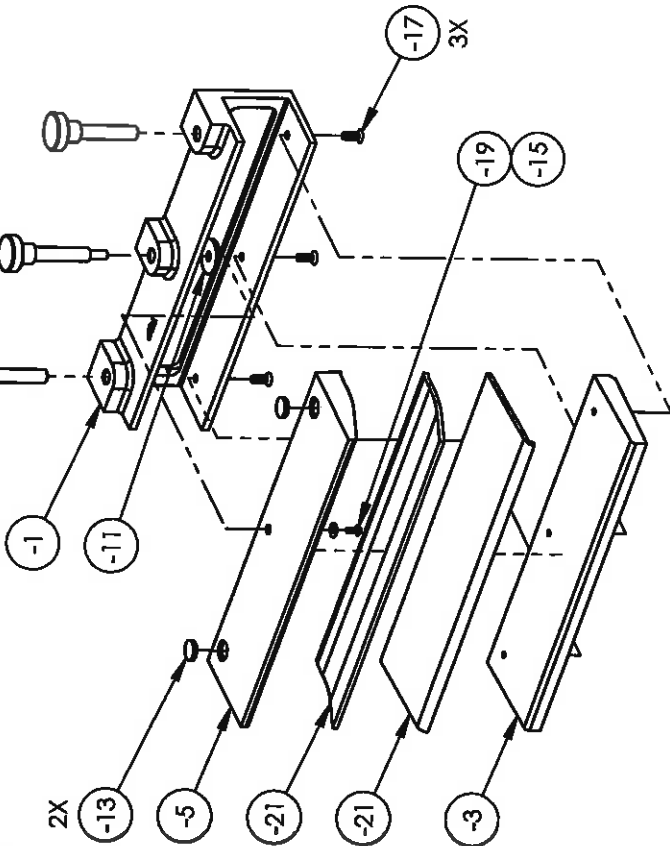
GA105

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBW6205G03832-3GP	Main Rotor Blade Blocking/Protecting Assembly	1 Ea (1 ea)	100-Purchasing	S214/273
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G03832-3GP	1	0	0
Part Specifications				
Specifications could not be found.				

Plex 7/19/19 2:28 PM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained herein are the sole property of Dart Aerospace, Inc. and are not to be reproduced or used in any fashion without the prior written permission of Dart Aerospace Engineers, Inc.

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		1. CHD FINISH, CHD REF. DIM FROM 1.378, CHD CHAMFER DIM FROM 0.11 X 100° AND REAR OPENING FROM 1.437. -5 CHD INK STAMP NOTE, CHD ANGLE PRECISION TO 74.5, ADDED P.F. -13 TO 1.349 DIM. -9 CHD THREAD CALL OUT FROM #6-40 UNF. -13 ADDED P.F. -5.	3/28/2011	RJC	
2		-1 CORRECTED SECTION A-A DIMENSION FROM 1.795 TO 1.772.	10/3/2012	RJC	GE
3		-1 CHD DIMS WAS R.125 IS R.13. WAS R.042 IS R.06. -3 CHD DIM WAS R.125 IS R.13, REMOVED NOTE. -5 CHD DIMS WAS 0.549 IS LIMITS 0.530 - .557. WAS R.125 IS R.13, REMOVED NOTE, ADDED SECTION D-D. -7 CHD DIMS WAS 0.1000 MED. KNURL IS (0.1000) MED. KNURL. WAS 0.250 SPHER. IS SR.25 REMOVED NOTE. -9 CHD DIM WAS 0.1000 MED. KNURL IS (0.1000) MED. KNURL. CORRECTED CHAMFER CALL OUT. REMOVED NOTE. -11 REMOVED NOTE. -13 CHD DIM WAS 0.550 IS 0.5512. .5515, REMOVED NOTE.	4/9/2014	DPD	RJC
4	15-0311	-1 CHD ENGRAVE NOTE WAS PAINT BLACK AFTER PAINTING YELLOW IS FILL LETTERS WITH WHITE PAINT AND ADDED 11.	9/25/2015	RJC	JAG
5	17-0057	-1 MOVED LOCATION OF MACHINE ENGRAVING, CHD DIM WAS 2.17 IS 2.1644-0.010. -3 CHD NOTE WAS INK STAMP P/N IS LASER ENGRAVE P/N. -5 CHD NOTE WAS INK STAMP P/N IS LASER ENGRAVE P/N.	3/6/2017	DPD	JAG



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198017 MJS
19-07-22

NOTE:
PART OF KIT RBW6205G03532-3G.

PART INFORMATION OR SPECIFICATIONS				B/O INFORMATION OR SPECIFICATIONS		PG.	
ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	PG.	
		-1	1	FRAME	6061	2	
		-3	1	BOTTOM	PHENOLIC	3	
		-5	1	TOP	PHENOLIC	4	
		-7	2	THUMB SCREW	303 S.S.	5	
		-9	1	CLAMP THUMB SCREW	303 S.S.	6	
		-11	1	FLAT WASHER	6061	7	
		-13	2	DISC	303 S.S.	8	
	B/O	-15	1	FLAT WASHER	6061-T6	1	
	B/O	-17	3	FLAT HEAD MACHINE SCREW	STEEL	1	
	B/O	-19	1	ROUND HEAD MACHINE SCREW	STEEL	1	
	B/O	-21	2	FELT PAD W/ADHESIVE BACK	FELT	1	

TITLE		REV	
M/R BLADE BLOCKING/PROTECTING ASSY.		5	
DWG NO.		RBW6205G03832-3G	
MATERIAL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS 1/16	
FINISH		.XXX ± .005 FRACTIONS 1/16	
BEG		.XX ± .01 ANGLES ± 8°	
DRAWN BY:		CLOUGH	
CHECKED:		RJC 03/07/2017	
OPPS APPR:		AA 03/09/2017	
QA APPR:		JL 03/16/2017	
APPROVED:		JAG 04/03/2017	
SCALE		1:5	
DATE		2/2/2011	
SHEET 1 OF 8			

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		Date: _____ Sequence #: _____ Description Work Order Deviation _____ Disposition _____ QTY Affected: _____ MRB (QS1042) _____		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																											
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																
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Mislabeled	Fit/Function	Off-set/Set-up																																	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044082



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044082

PO Date: 7/22/19

Due Date: 8/30/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-07-23

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198016	RBW6205G03632-3GP			Main Rotor Trim Tab Bending Tool	Firmed	-	8/30/19	1 Ea	0 Ea	1 Ea	\$897.00/Ea	\$897.00
2	198017	RBW6205G03832-3GP			Main Rotor Blade Blocking/Protecting Assembly	Firmed	-	8/30/19	1 Ea	0 Ea	1 Ea	\$2,065.00/Ea	\$2,065.00
												Grand Total: \$2,962.00	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 7/22/19 3:40 PM Dart.Guerin.Kimberley



METAL TECHNOLOGY INC.

www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25822
Shipment Date: 13-Sep-2019
Ship Via:
Order Number: 4027
Order Date: 07/23/2019

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB044082
Terms: Net 60 Days

Quantity								Job
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Number
2	1	1	0	0	EA	DART-RBW6205G03832-3GP M/R Blade Blocking/Protecting Assy	5	4027-02

RECEIVED

SEP 16 2019

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.

Page 1 of 1



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
1	DART-RBW6205G03832- 3GP	M/R Blade Blocking/Protecting Assy	5	HB044082

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

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George Theoret

Vankleek Hill, September 12, 2019